

## Front Bumper/Facia Fit Above Headlamps

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Topic number	LI88.20-P-071570
Version	4
Function group	88.20 - Bumpers
Date	5/9/23
Validity	BR290
Reason for change	Adhesive item number changed

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### Complaint

Bulging of front bumper above headlamps (see attachment).

Function of headlights not blocked or impaired.

Attachments	
File	Description
<a href="#">Beanstandung.JPG</a> 	Bulging on bumper above the headlamp

### Cause

Bonding between bracket and bumper may be separating.

### Remedy

Detach front bumper and check whether the brackets can be easily removed without damaging or deforming the bumper (little to no (remaining) bond) or whether the bond is (still) too strong.

Depending on the result of the check, proceed as follows:

A) Brackets can be easily removed without damaging or deforming the bumper --> Carry out the following rework:



1. Clean the inner side of the bumper and the new holder then apply the primer A 009 989 75 71.
2. Attach 3M tape as per Attachment 1.
3. Apply additional adhesive beads (recommended A009 989 85 71) as per Attachment 2 between and next to 3M adhesive tape.

# XENTRY TIPS

4. Bond the brackets to the inner side of the bumper and allow to cure sufficiently.

B) Brackets cannot be removed without damaging or deforming the bumper (bond too strong)

1. Follow procedure as per A), and replace the bumper.

Attachments	
File	Description
<a href="#">Halter_mit_3M.JPG</a> 	Attachment 1
<a href="#">Kleberaupen.JPG</a> 	Attachment 2

Symptoms
Body > Bumper > Poor fit

Parts						
Part number	ES1	ES2	Designation	Quantity	Note	EPC
A2908850501			Left bumper bracket	1		X
A2908850601			Right bumper bracket	1		X

Operation numbers/damage codes				
Op. no.	Operation text	Time	Damage code	Note